

NCR-19-769



Dart Aerospace Ltd.
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RBE000-117
Job Sheet 195571



Part No: RBE000-117

Job Qty: 1 pcs

Part Name: Fuel Sump Drain Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/27/19

Job Tracking No:

Due Date: 6/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE000-117 Rev.B IPP Rev. A 19.01.15 New issue DP Verify DD/IPP Rev. B 19.02.20 drawing revision
DP Verify DD

Ship Via:

Bill of Materials



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Container No: S188227



Part: RBE000-117

Job No: 195571

Serial No/Batch: S188227

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 06/06/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Small Fab - 1	1 pcs	6/4/19	6/4/19	0.00	0.20	Small Fab - 1		
							Small Fab - 2		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	6/4/19	6/4/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		JUN 06 2019 DAS 40 9-89
120	Packaging 3-1 - Stock - B4B	1 pcs	6/4/19	6/4/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	1 pcs	6/4/19	6/4/19	0.00	0.00	QC 21 - FG - 21		
							QC 21 - FG - 70		
							QC 21 - SA - 53		JUN 07 2019 DAS 21 9-89

Part Op 100 - Assemble as per DWG.
 Descriptions:

CORNER

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
108-0303-001	Banana Plug, Black	1 Ea (1 ea)	100-Small Fab	
		- 1		5155500
7113K341	Ring Terminal, 16-14ga 7113 K12	1 Ea (1 ea)	100-Small Fab	
		- 1		5165851
7132K111	Heat Shrink, Chemical Resistant, Black	2 Ea (2 ea)	100-Small Fab	
		- 1		5148002
8876T13	Loop Clamp for 1/4" O.D., White	1 Ea (1 ea)	100-Small Fab	
		- 1		5148005
90273A559	Flat Head Machine Screw, 1/4-28 UNF X 3/4	2 Ea (2 ea)	100-Small Fab	
		- 1		5147225
91166A240	Washer M5 98032A466	2 Ea (2 ea)	100-Small Fab	
		- 1		5168128
9192K1	Single Conductor Wire 14ga	12 ft (12 ea)	100-Small Fab	
		- 1		5147967
92005A318	Screw M5 x 8mm 90272A826	2 Ea (2 ea)	100-Small Fab	
		- 1		5165843
AS568A-343	Viton Fluoroelastomer O-Ring, 4.142 O.D. X 3.725 I.D. X 0.210 same as 9464K173	1 Ea (1 ea)	100-Small Fab	
		- 1		5148088
BU-654-0	Safety Alligator Clip, Black 314-1132-ND	1 Ea (1 ea)	100-Small Fab	
		- 1		5165067
RBE000-117-3	Base Plate	1 pcs (1 ea)	100-Small Fab	
		- 1		5148466
RBE000-117-5	Rod	1 pcs (1 ea)	100-Small Fab	
		- 1		5157573
RBE000-117-7	Tube	1 pcs (1 ea)	100-Small Fab	
		- 1		5164413
RBE000-117-9	Plate	1 pcs (1 ea)	100-Small Fab	
		- 1		5164019

010215

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	108-0303-001	1	4	0
	7113K341	1	100	0
	7132K111	2	5	0
	8876T13	1	99	0
	90273A559	2	48	0
	91166A240	2	79	0
	9192K1	12	38	0
	92005A318	2	100	0
	AS568A-343	1	5	0
	BU-654-0	1	4	0
	RBE000-117-3	1	3	0
	RBE000-117-5	1	3	0
	RBE000-117-7	1	3	0
	RBE000-117-9	1	3	0

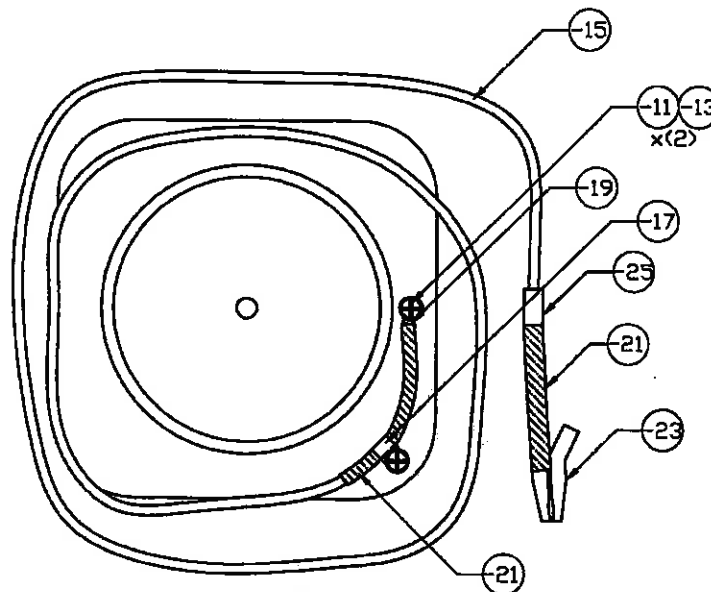
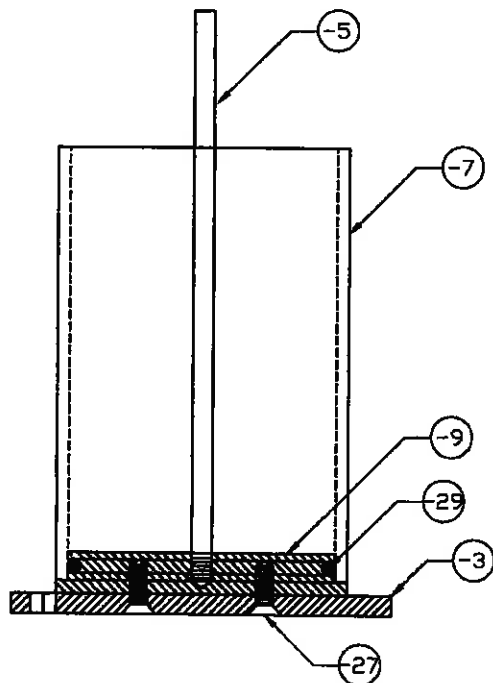
Part Specifications

Specifications could not be found.

Plex 6/6/19 7:38 AM dart.leclair.mathieu

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REV		DESCRIPTION	DATE	INITIAL	APPROVED
B	19-575	ITEM -23 WAS #BU-654-2 BLACK IS #BU-654-0 BLACK	2/12/2018	PK	PK



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WITHOUT NOTICE
WORK ORDER
NO. 195571 M15
19-05-27

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-3	1	BASE PLATE	6061	3/8 x 6 x 6	2
			-5	1	ROD	6061	Ø3/8 x 6	3
			-7	1	TUBE	CLEAR ACRYLIC	Ø4-1/2 O.D. x 4-1/8 I.D. x 6-3/4	4
			-9	1	PLATE	6061	Ø4-1/2 x 3/4	5
B/O			-11	2	SCREW		M5 x 8mm McMaster-Carr #92005A318	1
B/O			-13	2	FLAT WASHER		M5 McMaster-Carr #91168A240	1
B/O			-15	1	SINGLE CONDUCTOR WIRE	14 ga.	14ga. x 12 ft. BLACK McMaster-Carr #9192K1	1
B/O			-17	1	LOOP CLAMP	PLASTIC	FOR 1/4in. O.D. WHITE McMaster-Carr #8876T13	1
B/O			-19	1	RING TERMINAL		FOR 16-14ga. McMaster-Carr #7113K341	1
B/O			-21	2	HEAT SHRINK		CHEMICAL RESISTANT BLACK McMaster-Carr #7132K111	1
B/O			-23	1	SAFETY ALLIGATOR CLIP	NYLON HOUSING	MUELLER ELECTRIC #BU-654-0 BLACK PK.	1
B/O			-25	1	BANANA PLUG	NYLON HOUSING	JOHNSON COMPONENTS #108-0303-001 BLACK	1
B/O			-27	2	FLAT HEAD MACHINE SCREW	STEEL	1/4-28 UNF x 3/4 McMaster-Carr #80273A559	1
B/O			-29	1	VITON FLUOROELASTOMER O-RING		4.145 O.D. x 3.725 I.D. x .210 McMaster-Carr #A8568A-343	1

RED BARN MACHINE

FUEL SUMP DRAIN TOOL

DWC NO.		RBE000-117		REV	B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: CLOUGH			
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1		APPROVED: PK [Signature]			
FRACTIONS ± 1/32 ANGLES ± 5°		HEAT TREAT FINISH			
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SPEC			
SCALE NTS		DATE 6-24-10		SHEET 1 of 5	

Entered: JKDate: Nov 19NCR No. 19-7695

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>195571</u> Part No. <u>B8E000-17</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected : <u>1</u>	MRB (QSI042) <u>ML</u> <u>NOV 6/2019</u>	
Description Work Order Deviation McMaster #7113K341 IS McMaster#7113K12 McMaster #91166A240 IS McMaster#98030A466 McMaster #92005A318 IS McMaster#90272A826 DIGI-KEY# BU-654-0 IS DIGI-KEY#314-1132-ND ADD McMaster #91732A519 ITEM -3 DIM WAS M5 x 8mm THRU IS 10-32 UNF THRU 2 PL ADD ITEM -13 WHICH CONTAINS ITEM -9 AND McMaster# 91732A519		Disposition THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED		Completed By <u>ALAN PATRY</u> NOV 11 2019 Lead hand / Supervisor <u>DAS</u> <u>30</u> <u>9-89</u> <u>NOV 1 2019</u> QC / QA Coordinator <u>DAS</u> <u>68</u> <u>9-89</u> JUN 06 2019
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				